

## Work Order ID 58086

April 22, 2010 2:54:57 PM



Page 1

Item ID: D3836-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, LH)

Stop



Start Date: 22/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-4-22 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D3836	Rev A

100

0.00



Large Fab

Large Fab

Memo 0.00

1- cut D3836-1 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

4- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open  
to finish size as per dwg D38365- weld D2327-3 spacer bushing as per dwg D3836  
A/R ER316 S.S. Rod Batch: 111679

6- grind weld flush where indicated on dwg

②

10-05-05

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



Memo

0.00

Quality Control

② 10.05.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 58086**

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

140



QC

Quality Control

Operation  
Description

QC5- Inspect part completeness to step on W/O

Set Up/  
Run Hours

0.00

Draw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberReject  
NumberInspec.  
Stamp

SW105107



150



Packaging

Packaging

Identify as per dwg &amp; Stock Location: WA

0.00

SAP

0.00

10-05-07



160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/07 JF

MF 10-5-7

W/O:		WORK ORDER CHANGES					
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# Picklist Print

April 22, 2010 2:55:01 PM

Page 1

Work Order ID: 58086



Parent Item: D3836-041



Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 22/04/2010

Required Date: 29/04/2010

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2327-3 Manufactured No 100 Each 31.0000 2.0000



Spacer Bushing

*PL 10-05-05*

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

WA 31

57186 11

57790 20

M304TS0.750W.065 Purchased No 100 f 8.6105 3.7491



304 SQ Tube .75x.75x.065W

*2*

*SAP 10-05-05*

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

WA 8.610463158

111148 2.7967

113956 2.863

114137 2.95076316

*M114482* → *3,7491*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

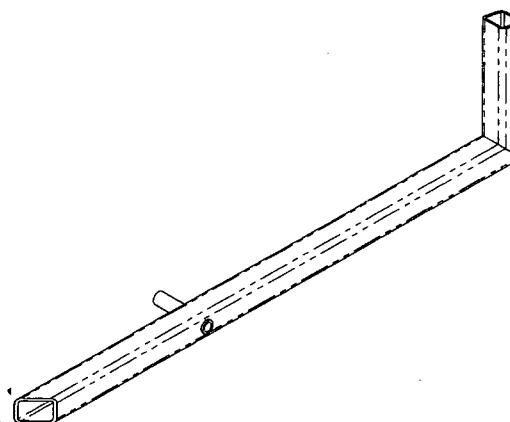
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

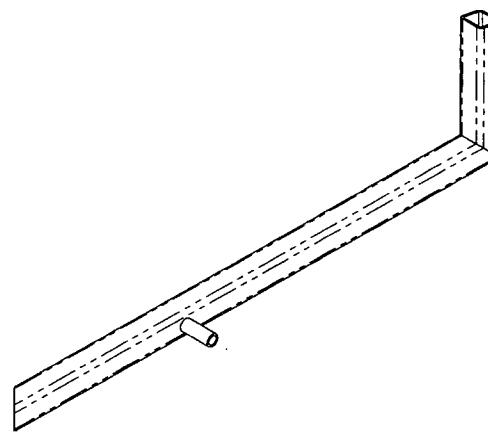
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

8 7 6 5 4 3 2 1

A  
NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.99 lbs EACH  
 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 58085*28/04/22*RELEASED  
*08/04/2022*

A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>A2-3</i>		
DRAWN			
CHECKED	<i>A2-3</i>		
MFG. APPR.	<i>M</i>		
APPROVED	<i>M</i>		
DE APPR.	<i>M</i>		
DATE	08.09.24		

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3836 REV. A  
SHEET 1 OF 3

TITLE RIB ASSY (BASKET LID) SCALE NTS

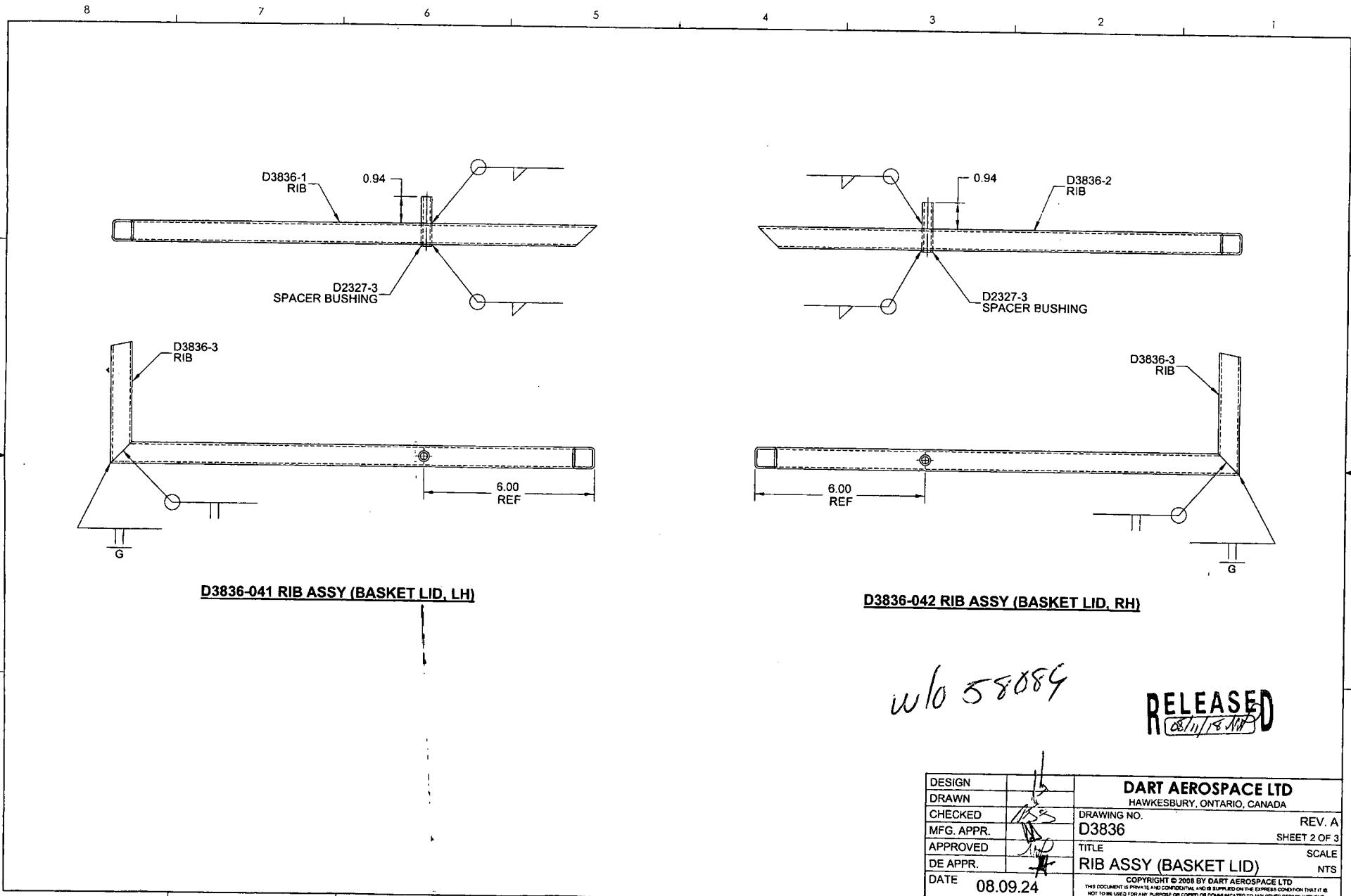
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NOTE: Date & initial all entries



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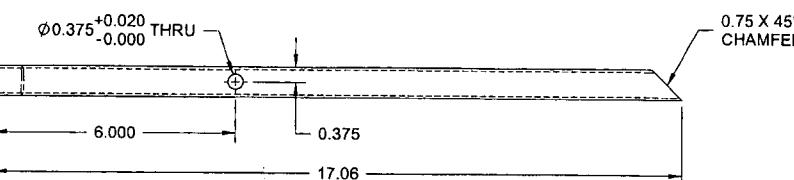
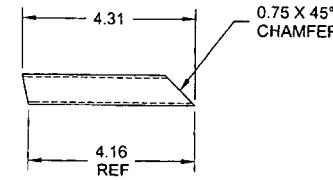
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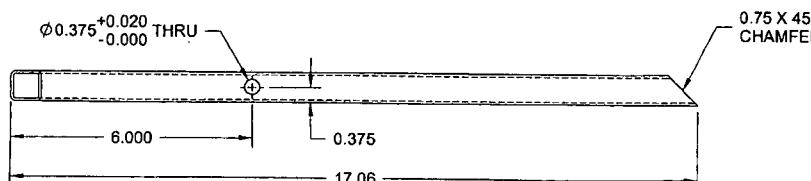
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

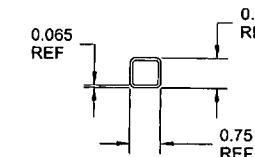
D

D3836-1 RIBD3836-3 RIB

C

D3836-2 RIB

a/c 58084

TYPICAL SECTION  
VIEWRELEASED  
08/11/18 J.W.

B

A

## NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

8 7 6 5 4 3 2 1

DESIGN	<u>1</u>	DART AEROSPACE LTD
DRAWN	<u>5</u>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<u>PASS</u>	DRAWING NO.
MFG. APPR.	<u>M</u>	REV. A
APPROVED	<u>M</u>	SHEET 3 OF 3
DE APPR.	<u>S</u>	TITLE
DATE	08.09.24	SCALE
		NTS
		RIB ASSY (BASKET LID)

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1

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